

Work Order ID 53764

November 17, 2009 8:55:51 AM

D-REV

54771



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09 Start Qty: 10.00



Cust Item ID:

Required Date: 12/11/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

11-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

507/12/12

HJ for B6 09/12/10

110

0.00



Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

PL

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *m11/311*

3-Grind End Plate flush *m11/494*

PL

PL 09.12.2

10

Work Order ID 53764

November 17, 2009 8:55:56 AM

Page 2

Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09 Start Qty: 10.00

Required Date: 12/11/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

D 09.12.02 15

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 809/12/03

410
RH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MD 09/12/03

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53764



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Item ID: D350-591-312

Accept



Setup Start



Revision ID: B

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 11/23/09 Start Qty: 10.00



Cust Item ID:

Required Date: 12/11/09 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

BR 09-12-3

10

0

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

Large Fab

Memo

0.00

1-Assemble Leg Assembly as per Dwg D3272. *th*

2-Leave one rivet out until welding is complete. *th*

3-Bevel Aft end for welding *th*

4-Inspect for foreign object as per QSI 024 *th*

5-Weld Aft End Plate as per QSI 004 & Dwg D3272 *th*

A/R ☐ Aluminum Rod ☐ *mill 311*

6-Grind End Plate flush *th*

7-Install last rivet as per Dwg. *th*

th 09.12.01

10

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D350-591-312

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Setup Start

Revision ID: B

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09 Start Qty: 10.00

Cust Item ID:

Required Date: 12/11/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

(10x) 0 BE 09/12/07

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 502/12/07

(+10 RH) /

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MD 09/12/07

X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Item ID: D350-591-312

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Revision ID: B

Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09 Start Qty: 10.00

Required Date: 12/11/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 1130

OVEN TEMPERATURE: 320°

FINISH TIME: 12:00

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch M112623

0.00



HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

P10 →

4 09/12/09

27 8 09/12/16

10

X10

X10

X10PH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-591-312 PAR #: _____ Fault Category: Large Fats NCR: Yes No DQA: _____ Date: 09.12.30
 Resolution: re-work Disposition: re-work QA: N/C Closed: _____ Date: 09.12.31

NCR: <u>53764</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/12/8	220	Qty +1 step Found with Dent in the Aft. End of in the end cap. wasn't seen at inspection. WAS Found before PC. (QSI or QCS) but miss handling	CP 09.12.08 pu QSI 042	- Drill out Dent - Fill with weld per as 2004 A/E MILL 311 - Grind welds flush.	PE 09.12.08	S 09.12.08	CP 09.12.08 pu QSI 042	S 09.12.08
		of parts. Not by welder! R.C. LOA	CP 09.12.08	- Re align.	BR 09.12.08		CP 09.12.08	S 09.12.08

NOTE: Date & initial all entries

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Item ID: D350-591-312

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Start Date: 11/23/09 Start Qty: 10.00

Required Date: 12/11/09 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/12/9 (100) SP

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

⇒ 8012/16

(110 RH)

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312
Location: _____

B

9/12/18 (100) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53764

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Item ID: D350-591-312

Accept

Revision ID: B

Item Name: Heli-Access-Step, Long RH

Setup Start

Stop

Start Date: 11/23/09 Start Qty: 10.00

Required Date: 12/11/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/12/21

(209112121)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/23/09

Required Date: 12/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3065-041RevB		Manufactured	No				Each	72.0000	10.0000			
---------------	--	--------------	----	--	--	--	------	---------	---------	--	--	--



Step Leg Assembly Hi

11/23/09-12.07

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	32	
----	----	--

53523	32	
-------	----	--

Main Warehouse

WA	40	
----	----	--

52104	40	
-------	----	--

D3066-1RevB		Manufactured	No				Each	101.0000	20.0000			
-------------	--	--------------	----	--	--	--	------	----------	---------	--	--	--



Spacer

10

11/23/09-12.07

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	101	
----	-----	--

51545	14	
-------	----	--

52662	87	
-------	----	--

D3219-1RevA		Manufactured	No				Each	68.0000	20.0000			
-------------	--	--------------	----	--	--	--	------	---------	---------	--	--	--



Plate

20

11/23/09-12.02

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST	68	
----	----	--

52230	68	
-------	----	--

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH



Start Date: 11/23/09

Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3067-1RevA ✓  End Plate		Manufactured	No			110	Each	97.0000	10.0000 		<i>12.09.12.02</i>	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

97

51546

8

53451

89

D3272-1RevB ✓

Manufactured

No

110

Each

0.0000

10.0000


Step

MS21042L5 1 x2

Purchased

No

110

Each

926.0000

20.0000


Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

926

110382

10

111127

4

111636

15

112314

897

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Shop Packet Print

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Picklist Print

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Page 3

Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/23/09

Required Date: 12/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS20600-AD4W4		Purchased	No			180	Each	2,015.000	160.0000			
---------------	--	-----------	----	--	--	-----	------	-----------	----------	--	--	--



Rivets

12 09.12.07

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	2015	
110731	215	
111359	46	
111477	74	
112314	1656	
112385	24	

160



Bolt

Purchased	No			260	Each	421.0000	20.0000
-----------	----	--	--	-----	------	----------	---------



9/12/10 sf 120

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	421	
106993	12	
110467	1	
112314	408	

20

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Page 4

Work Order ID: 53764



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09

Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-13A ~		Purchased	No			260	Each	299.0000	80.0000			



Bolt



9/12/10 sf 10x

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

299

107321

1

107534

5

107959

23

109285

37

110552

66

110865

3

111477

9

111925

7

112314

48

113149

100

17406

0

51764

0

M113359

80x

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Page 5

Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09

Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-36A Bolt		Purchased	No			260	Each	351.0000	20.0000		9/12/10	sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	351	
109545	11	
110467	7	
110731	4	
112243	20	
112314	259	20
112385	50	

AN960JD10



Washer

Purchased

No

260

Each

2,498.000 40.0000

9/12/10 40 sf

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	2498	
105442	19	
109059	2	
109840	23	
110985	202	
111279	5	
111668	64	
112314	965	40
112369	218	
113149	1000	

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Work Order ID: 53764



Parent Item: D350-591-312RevB



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Start Date: 11/23/09

Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	AL6	Purchased	No			260	Each	3,603.000	160.0000			



8
ft Washer



9/12/10 SL

(10x)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3603

108161

329

110523

340

111279

101

111916

482

112314

2351

16941

0

160

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Start Date: 11/23/09

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Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD516		Purchased	No			260	Each	1,692.000	40.0000			



Washer

9/12/10 54

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1692	
100564	2	
106167	6	
107534	34	
107959	43	
108246	46	
108672	2	
109059	49	
109752	22	
110363	46	
110523	57	
111279	39	
112082	64	
112314	282	
112828	500	
113149	500	

40

Picklist Print

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Work Order ID: 53764

Parent Item: D350-591-312RevB

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Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2230-3RevG		Manufactured	No			260	Each	169.0000	40.0000			
-------------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



Lug

B53450 9/10/10 50 10x

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST

3

51568

3

Main Warehouse

ST176

166

51428

166

D2618RevB1

Manufactured No

260

Each

251.0000

20.0000



Bushing

9/12/10 10x 50

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

ST39

251

50989

200

51189

51

20

November 17, 2009 8:55:37 AM

Shop Packet Print

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Picklist Print

November 17, 2009 8:55:45 AM

Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/23/09

Required Date: 12/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2856-400RevA

28 7.2"

Manufactured

No

260

f

360.0237

6.0000

Abraison Strip

9/18/10 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

360.0236842

50593

144.023684

52563

216

D3067-1RevA

Manufactured

No

260

Each

97.0000

10.0000

End Plate

2x each

9/12/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

97

51546

8

53451

89

D3235-1RevA

12

Manufactured

No

260

Each

93.0000

20.0000

Mounting Lug

9/12/10 10x 54
B5378511X 6/9/12/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

93

45398

4

47969

89

9x

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Picklist Print

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Work Order ID: 53764

Parent Item: D350-591-312RevB

Parent Item Name: Heli-Access-Step, Long RH

Comments:

Start Date: 11/23/09

Required Date: 12/11/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3278-041RevC		Manufactured	No			260	Each	73.0000	10.0000			
---------------	--	--------------	----	--	--	-----	------	---------	---------	--	--	--



Support Assembly

9/12/10 SP

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

52075

73

10x

MS21042L3

Purchased

No

260

Each

3,038.000 20.0000



Nut

9/12/10 SP 100

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3038

110844

32

111274

27

111668

487

112314

1992

112385

500

20

November 17, 2009 8:55:45 AM

Shop Packet Print

Page 10

Picklist Print

November 17, 2009 8:55:51 AM

Work Order ID: 53764



Parent Item: D350-591-312RevB



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 11/23/09

Required Date: 12/11/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4	tb	Purchased	No			260	Each	5,129.000	80.0000			



9/12/10

sl

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5129

110507

184

111827

4938

112314

7

15924

0

80x



DESIGN <i>90</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

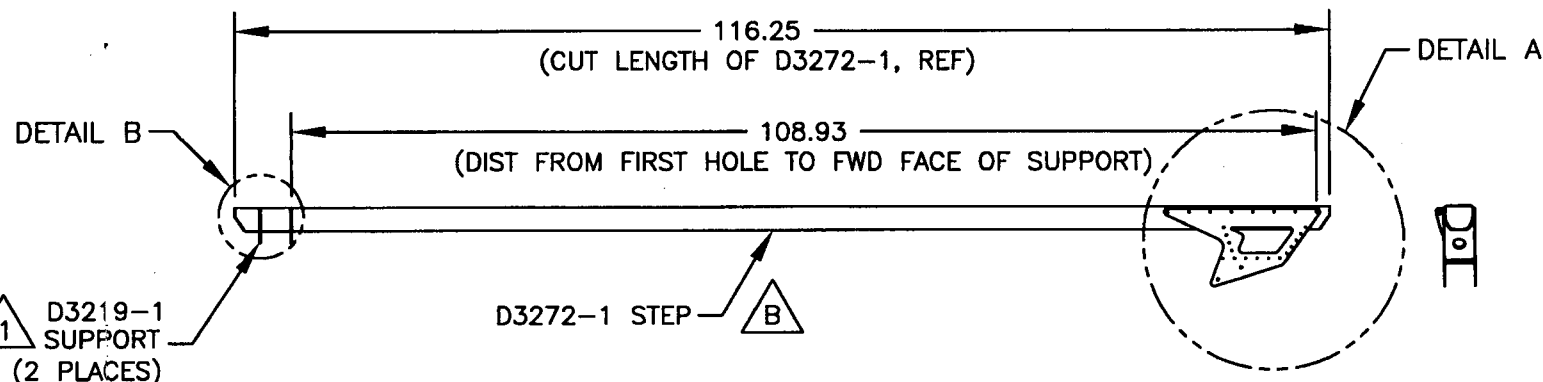
SHOP
REVIEW
ENCLOSURE
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. *53764*
09-11-17

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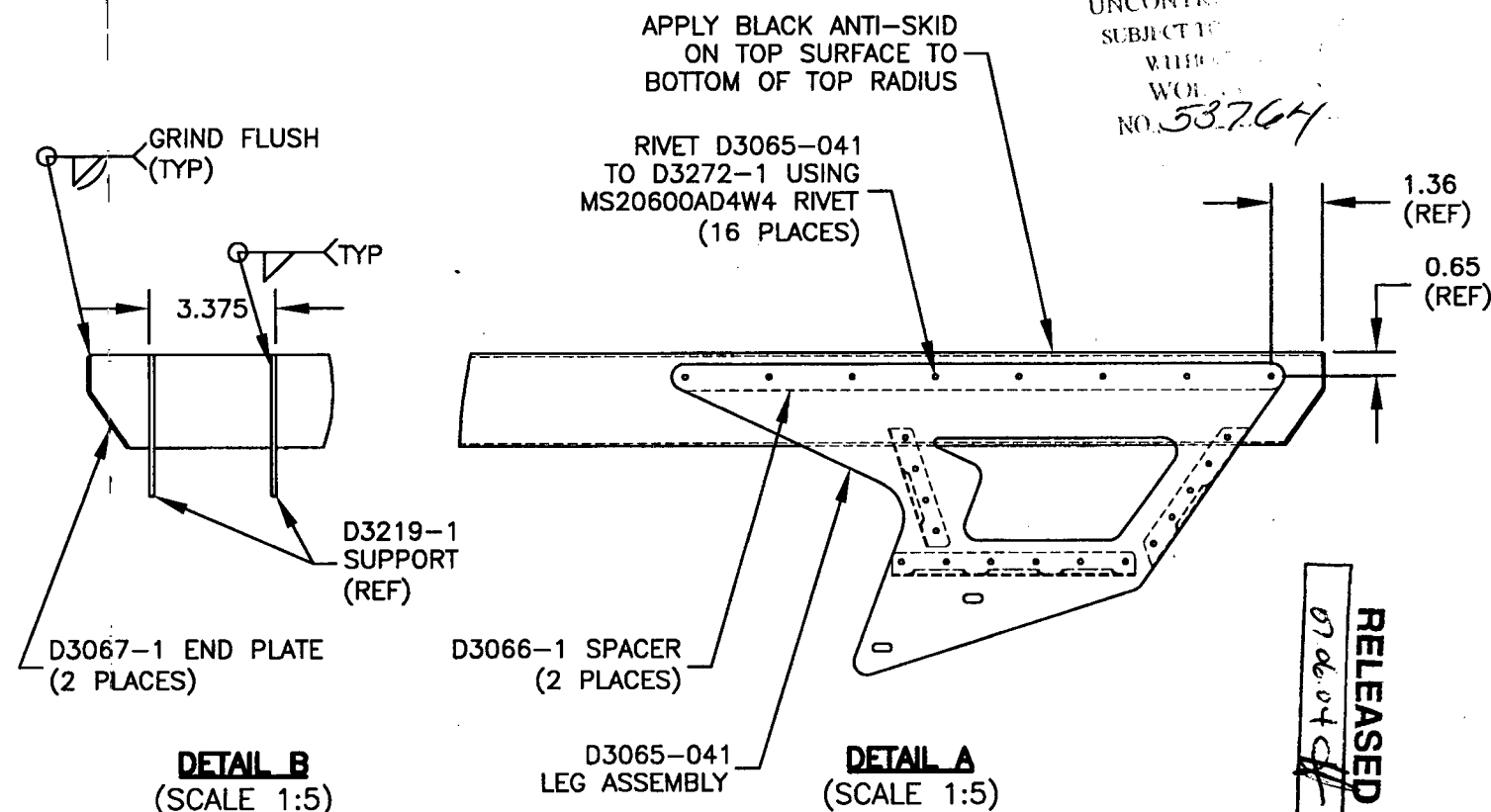
DART

DESIGN	90	DRAWN BY	90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	CE	REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
			STEP ASSEMBLY, HI LONG	SCALE 1:20



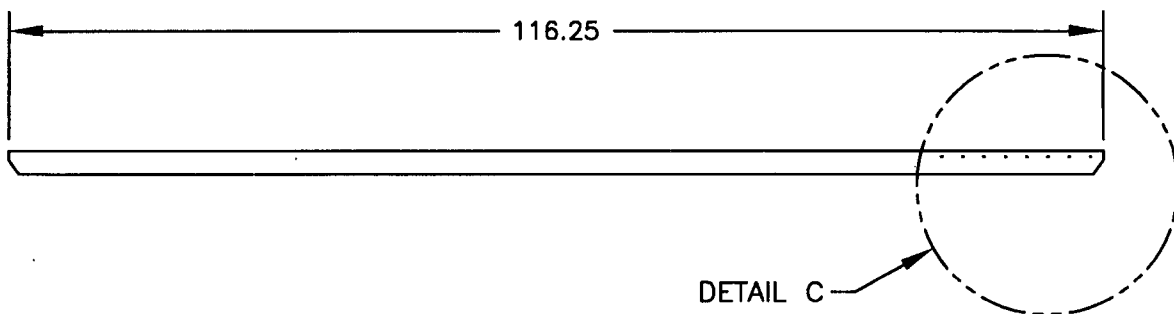
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

SHO
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 WITH
 WO
 NO. 53764



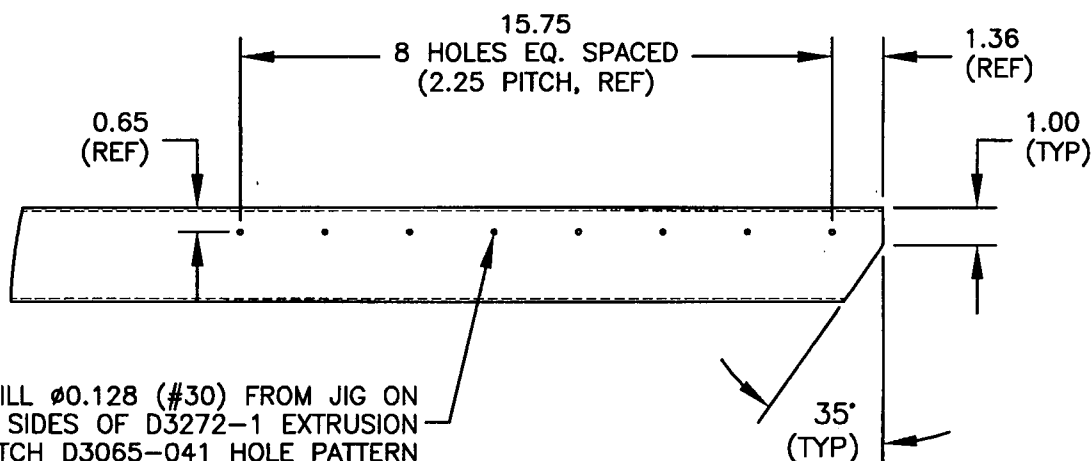
DART

DESIGN	AP	DRAWN BY	JR	DART AEROSPACE LTD	REV. B
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA	
DATE	07.05.18	DRAWING NO.	D3272	SHEET 3 OF 3	
		TITLE	STEP ASSEMBLY, HI LONG	SCALE	1:20



△ B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53764



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

53764